

Work Order ID 111763

Tuesday, January 21, 2014 11:37:01 AM

111763

ASAP

TULMPR Page 1

Item ID: PB67-43001-33 Accept

Revision ID:

P B67-43001-33

N900040100

Setup Start ***NS1***

Item Name: Upper Pad Assembly

B111763

Stop ***NS2***

Start Date: 1/21/2014 Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/14/2014 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: UWF Date: 4-1-21

Tooling:

Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

B67-43001-33

Rev C

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001-325***Use cutting file -325***** Dwg

2024-032

Rev: C Prog Rev: C

2-Deburr if necessary

18 0 Jm 14-02-3

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

18 0 Jm 14-02-3

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89
14/1/3

18 0 Jm 14-02-3

→
PTO

DQA:

Date: 14/04/08



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 14/4/14

Work Order update only ☐

Work Order: <u>111763</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>PB 67-43001-33</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>14-3704</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data	14/3/4	100	12	FOAM: SBR/EDM/CIR BLEND, BLACK, ASTM D1056 ZAZ, 0.50 THK. ADHESIVE: LA4009 NNOOC	DAS 12 9-89 14/3/4	Acceptable deviation PART IS NOT AIRWORTHY	DAS 12 9-89 14/3/4	DAS 27 9-89 14/3/28	DAS 21 9-89 14/3/28
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Tuesday, January 21, 2014 11:37:01 AM

1 1 1 7 6 3

Page 2

N900040100

Setup Start *NS1*

Item Name: Upper Pad Assembly

Stop *NS2*

Start Date: 1/21/2014 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 3/14/2014 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

* Stop

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Equip/Tooling									
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Page 3

Item ID: PB67-43001-33 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Pad Assembly
Start Date: 1/21/2014 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/14/2014 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160	<i>M125028</i>					<i>18</i>	<i>φ</i>	<i>14-2-6</i>	<i>DAS 34 9-89</i>
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>8:50</i> FINISH TIME: <i>9:20</i> OVEN TEMPERATURE:								
170	QC3- Inspect Part Finish	0.00							
170						<i>18x</i>		<i>14/22/06</i>	<i>DAS 36 9-89</i>
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
180						<i>18x</i>		<i>14/22/06</i>	<i>DAS 36 9-89</i>
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg B67-43001								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DQA: _____ Date: _____



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Work Order ID 111763

Tuesday, January 21, 2014 11:37:01 AM

111763

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Item ID: PB67-43001-33 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Pad Assembly
Start Date: 1/21/2014 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/14/2014 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				18			
230 *230* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				14/3/27	(18)		DAS 32 9-89
240 *240* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MCJ 14-03-28			

POSITIVE RECALL

EFFECTIVE 14/3/4 AUTH 4
RELEASED 14 DATE 14/3/28

CHECK FORM (RNGIT)

mf
14-3-28

DQA: _____ Date: _____



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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, January 21, 2014 11:37:00 AM

Page 1

Work Order ID: 111763

Parent Item: PB67-43001-33

Parent Item Name: Upper Pad Assembly

Start Date: 1/21/2014

Required Date: 3/14/2014

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-06-20 new issue DD verified by:ec
dwg EC verified by:DD

IPP Rev C 10.09.28 per rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.032		Purchased	No			180	sf	363.8000	0.3064	6		Jan 14-02-3	
2024-T3 .032 sheet													

Location	Loc Qty	Loc Code
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MAT022	363.8	
121309	7	
123574	14	
124987	10	
M127668	332.8	

MS20426AD3-4 RIVET		Purchased	No			180	Each	11,131.000	10	120			
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Location	Loc Qty	Loc Code
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ST334	4000	
m127432	4000	
ST509	7131	
125578	7131	

MS21075L3 Nut Plate	MS21075L3N	Purchased	No			100	Each	75.0000	5	60			
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Location	Loc Qty	Loc Code
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GA	75	
125646	75	

DAS
36
9-89

DAS
36
9-89

M123352
180x

M127993
90x

DQA: _____ Date: _____



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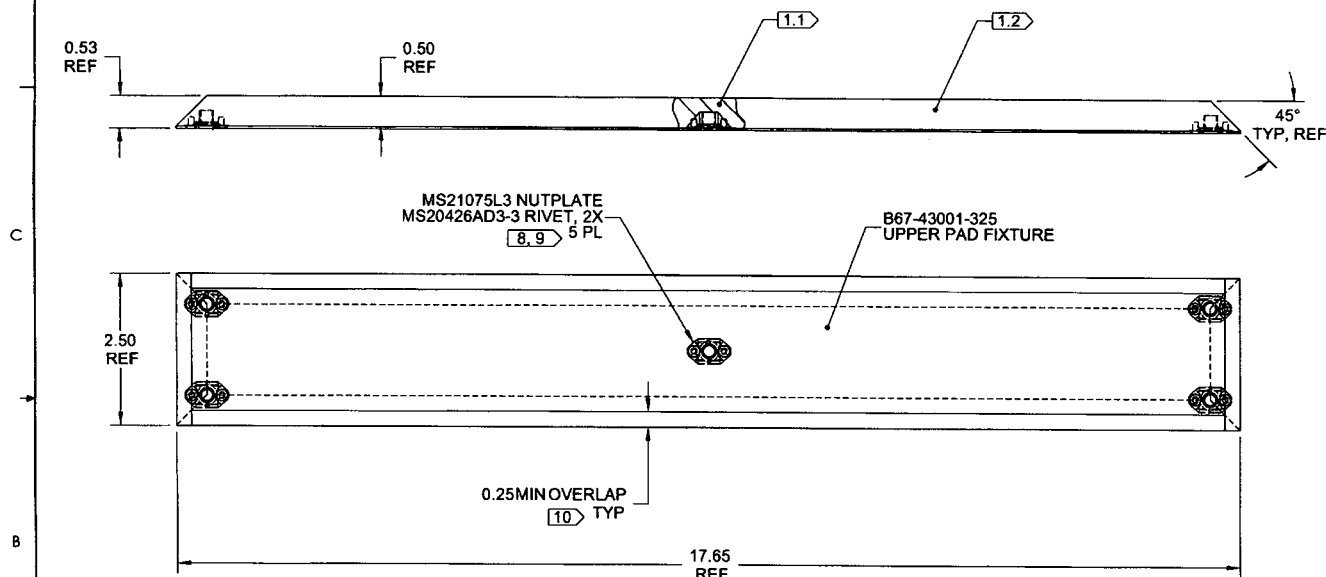
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ITEM	QTY -33	P/N	DESCRIPTION
1	x	B67-43001-33	UPPER PAD ASSEMBLY
2	1	B67-43001-325	UPPER PAD FIXTURE
3	5	MS21075L3	NUT PLATE
4	10	MS20426AD3-3	RIVET
5	A/R	1637-001	SEE NOTE 1.1
6	A/R	1495	SEE NOTE 1.2
7	A/R	LA4009	SEE NOTE 1.3



B67-43001-33 UPPER PAD ASSEMBLY

NOTES:

1) MATERIAL:

1.1) FOAM: ETHYLENE PROPYLENE NEOPRENE SBR CLOSED-CELL, FLAME RETARDANT, 0.50 THICK, PER ASTM D1056 2A2, SERVICE TEMP -40°F TO +200°F, COLOUR: BLACK
REF. TULMAR P/N 1637-001

1.2) FABRIC: 100% 420 DENIER NYLON, MIN THREAD COUNT 35X35, POLYURETHANE COATED ONE SIDE, COLOUR: BLACK
REF. TULMAR P/N 1495

1.3) ADHESIVE: URETHANE WITH CATALYST, TWO PART, CLIFTON LA4009

2) FINISH: BOND NEOPRENE TO COVER PLATE USING ADHESIVE. COVER WITH DENIER AS SHOWN.

3) TOLERANCES: PER TABLE 1 (ZN A3-1) UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: 0.22 lbs REF

8) NUTPLATES AND HOLES MUST BE FREE OF ADHESIVE AND FABRIC

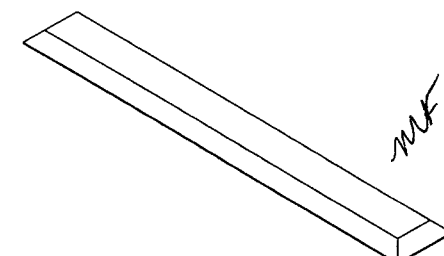
9) IT IS ACCEPTABLE TO RELIEVE FOAM WHERE THE NUTPLATES ARE LOCATED TO ENSURE ADEQUATE BONDING OF FOAM TO PLATE

10) DENIER NYLON TO BE BONDED ALL AROUND INNER SIDE OF PLATE

TABLE 1

TOLERANCES ON FABRIC (PARTS AND ASSEMBLIES)
±1/8: DIMS <2
±1/4: DIMS 2 TO <10
±1/2: DIMS 10 TO <20
±5/8: DIMS 20 TO <40
±1.5%: DIMS EQUAL TO OR > 40

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018, QSI 043 AND TULMAR SAFETY SYSTEMS INC.'S MANUFACTURING PROCESS AND TOLERANCES ON FABRIC. FOR PREVIOUS REVISIONS, REFER TO SHEET 41 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.27
REV.	DESCRIPTION	BY	DATE
DESIGN	R/W		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	10.04.27		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-33 TITLE UPPER PAD ASSEMBLY SCALE NTS SHEET 1 OF 1 REV. C COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



RELEASED
2010-09-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

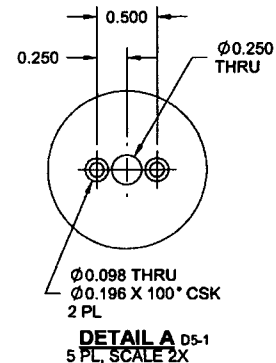
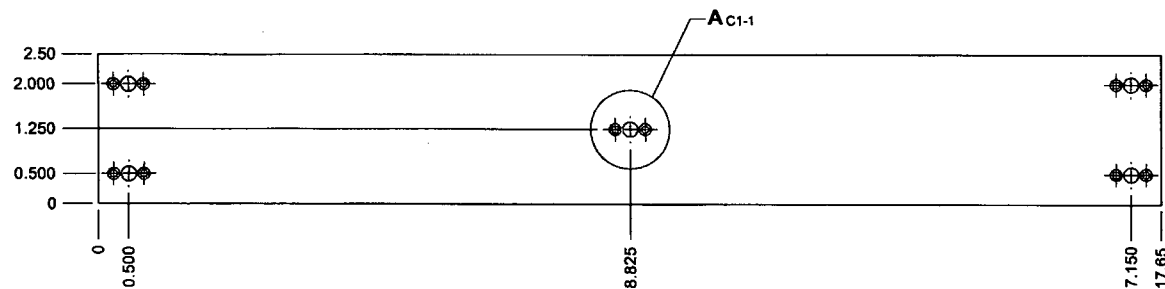
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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B67-43001-325 UPPER PAD FIXTURE

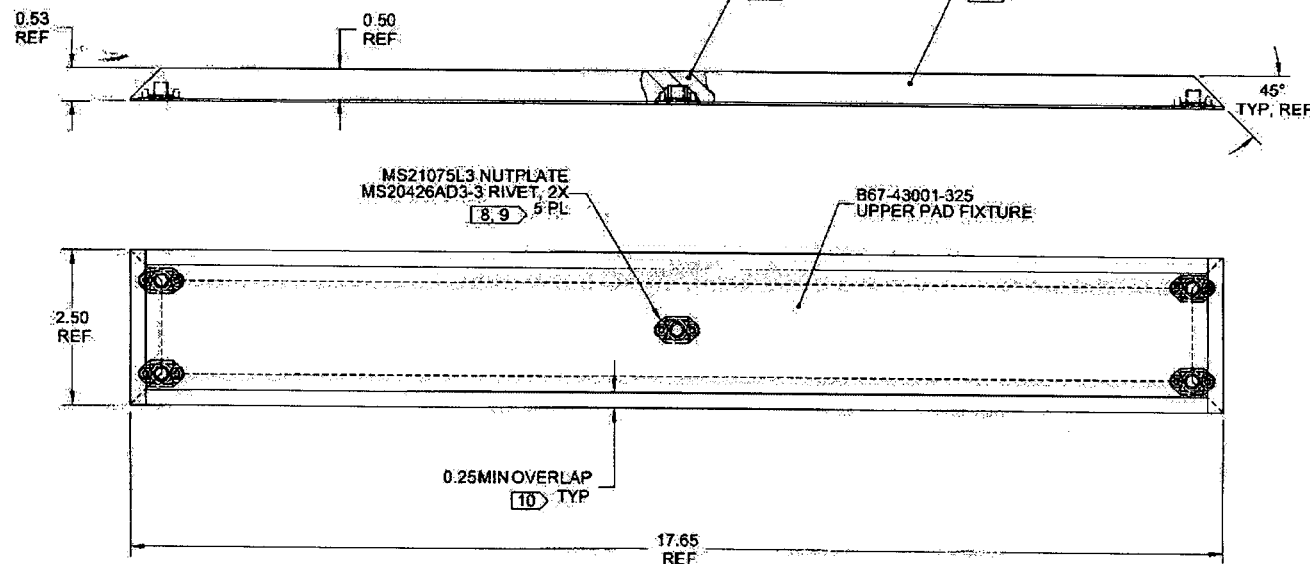
RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 41 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C SHEET 1 OF 1 SCALE NTS	
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.	N/A	UPPER PAD FIXTURE		
DATE	10.04.27	COPYRIGHT © 1986 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

ITEM	QTY -33	P/N	DESCRIPTION
1	x	B67-43001-33	UPPER PAD ASSEMBLY
2	1	B67-43001-325	UPPER PAD FIXTURE
3	5	MS21075L3	NUT PLATE
4	10	MS20426AD3-3	RIVET
5	A/R	1637-001	SEE NOTE 1.1
6	A/R	1495	SEE NOTE 1.2
7	A/R	LA4009	SEE NOTE 1.3



B67-43001-33 UPPER PAD ASSEMBLY

NOTES:

- 1) MATERIAL:
 - 1.1) FOAM: ETHYLENE PROPYLENE NEOPRENE SBR CLOSED CELL, FLAME RETARDANT, 0.50 THICK, PER ASTM D1056 2A2, SERVICE TEMP -40°F TO +200°F, COLOUR: BLACK, REF. TULMAR P/N 1637-001
 - 1.2) FABRIC: 100% 420 DENIER NYLON, MIN THREAD COUNT 35X35, POLYURETHANE COATED ONE SIDE, COLOUR: BLACK, REF. TULMAR P/N 1495
 - 1.3) ADHESIVE: URETHANE WITH CATALYST, TWO PART, CLIFTON LA4009 OR LA4009NOVOC.
- 2) FINISH: BOND NEOPRENE TO COVER PLATE USING ADHESIVE. COVER WITH DENIER AS SHOWN.
- 3) TOLERANCES: PER TABLE 1 (ZN A3-1) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.22 lbs REF.
- 8) NUTPLATES AND HOLES MUST BE FREE OF ADHESIVE AND FABRIC.
- 9) IT IS ACCEPTABLE TO RELIEVE FOAM WHERE THE NUTPLATES ARE LOCATED TO ENSURE ADEQUATE BONDING OF FOAM TO PLATE
- 10) DENIER NYLON TO BE BONDED ALL AROUND INNER SIDE OF PLATE

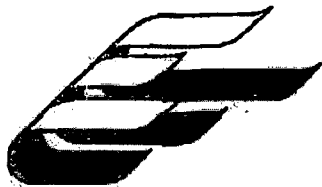
TULMAR MARK-UP
REV I
03/03/2014 RL

RELEASED
2010-09-16

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018, QSI 043 AND TULMAR SAFETY SYSTEMS INC.'S MANUFACTURING PROCESS AND TOLERANCES ON FABRIC. FOR PREVIOUS REVISIONS, REFER TO SHEET 41 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PARA09-011.	MB	10.04.27
REV.	DESCRIPTION	BY	DATE
DESIGN	R/W		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	10.04.27		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-33 TITLE UPPER PAD ASSEMBLY REV. C SHEET 1 OF 1 SCALE NTS			
COPYRIGHT © 1995 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ON ANY COMMERCE WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

TABLE 1 (3)

TOLERANCES ON FABRIC (PARTS AND ASSEMBLIES)
±1/8" DIMS <2
±1/4" DIMS 2 TO <10
±1/2" DIMS 10 TO <20
±5/8" DIMS 20 TO <40
±1.5% DIMS EQUAL TO OR > 40



J. ENNIS FABRICS

October 7, 2013

Fax To: Tulmar Safety Systems
Fax: 613-632-2030
Attention: Meagan

Certificate of Conformance

Re: PO 26380-00 for Oxford 7 Black

The goods shipped on P/O 26380-00 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford 7 Black is in compliance with the following standards:

Width: Product is 58 inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

Content: 100% Nylon

Coating: Product has a Polyurethane Coating (approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.))

Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish: Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

Piece # Various Manufacture Date: 05/17/13, Lot Number: 422038

Sincerely,
J. Ennis Fabrics Ltd.

C. Harris

Crystal Harris
Customer Service Specialist

TSS 8421-107
DWG B67-43001-33+M41

1495/29.



TULMAR

Certificate of Conformance

Tulmar P/N 1637-001	Description NEOPRENE Foam ARTM D1056-2A2	Dwg #	Revision	Qty 1547
Tulmar PO # 25932-00	Line Item # 1	Supplier Name / Address AM Rubber + Foam Products Inc.	Supplier Packing Slip # 11152	

Supplier Declarations:

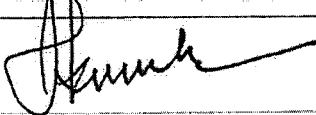
Hazardous Materials Acknowledgement	The items described below may contain, and their processing may have included, the following substances:	Hexavalent Chromium; Cadmium; Beryllium; Nickel; Mercury; Lead; Asbestos; Radioactive elements YES ☐ NO ☒
Country of Origin of Goods :	Canada	if YES, please complete the HazMat Acknowledgement form @ www.tulmar.com
Limited Shelf-Life	<u>Definition:</u> If material is consumed or transformed into final product before end of shelf-life there is no effect on final product.	These items have a limited Shelf-Life YES ☐ NO ☒
Expiry date	<u>Definition:</u> Date after which performance will no longer be as intended - expiration is transferred to the final product.	These items have an expiry date YES ☐ NO ☒

if YES, please complete the Time Expired - Shelf-Life questionnaire @ www.tulmar.com

Additional Information (MRS#, MRA#, limitations, etc...):

--

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. Objective evidence to support this statement is on file and can be made available upon request. Should further information be required, please contact:

Signature 	Name JOSEPH MATHEW	Date (DD-MMM-YYYY) 08/19/13
Title Manager - QA	Email joemathew@amrubber.ca	Phone # 6475011449

AUG 28 2013



TSS 1637-001
B #4

Form Revision 13 Aug 2012

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8
Canada
PST 6879 7176
Tel: 613-632-1282
Fax: 613-632-2030

elyse@tulmar.com

Purchase order

PO number

25932-00

The P.O. Number must appear
on all related correspondence,
shipping papers and invoices.

Page

Page 1 of 1

PO date

8/13/2013

Order type

Normal

Ordered From

AM Rubber & Foam Gaskets Inc.
2074 Steeles Ave, East
Units 1&2
Brampton, ON L6T 4Z9
Canada
Joseph Mathew
joemathew@amrubber.ca

Ship to

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8
CA

Buyer

Elyse Timbers

Terms

Net 30 Days

Ack / Con

Yes Yes

FOB

Origin

Ship via

Fedex

PPD/COL

Collect

Line No	Qty Ordered	UOM	Our Item Number/Description	Your Item Number	Unit price	Extended Price	Requested
1	1.00	SH	1637-001 Foam, SBR, Closed Cell ASTM D1056 2A2, 1/2", 42"x72" Ethylene propylene neoprene Flame retardant, service temp -40°F to +200°F Quality Clause: GrBT3		80.0000	80.00	14-Aug-2013

3/04

Total Extended Price CAD = 80.00

Total Applicable Taxes = 10.40

It is the supplier's responsibility to obtain a copy of Tulmar's Quality Clauses by visiting the supplier page on our website. www.tulmar.com
Charges for any insured shipments will be refused. Do not enter a declared/carriage value.

Consolidate items unless otherwise stated.

US suppliers must include a NAFTA certificate and Canada Customs invoice with every shipment.

Comments

COC - email to sqa@tulmar.com
Cert. of Origin with shipment



Date: 11/18/13

LA4009

Shipper #: 755

Certificate of Compliance

This letter certifies that 110 x 1 gallon cans of LA4009 Polyurethane Adhesive,

**Drawing No: (Ref 10557979)

lot number: PNJ-1113-041 was shipped to you on 11/18/13. **DWG REV: "A" Royal Adhesive & Sealants,

LLC - Aerospace & Marine Inflatable Adhesives & Coatings Division manufactured this material according to internal specifications which include quality control and assurance procedures. The material was manufactured on 10/22/13 against your Purchase Order # 26618.

Shelf Life: 1 year from date of manufacture

Expiration Date: 10/22/14

This letter certifies that 19 x quart cans of CATUV Accelerator, Lot number PNJ-1113-040 was shipped to you

on 11/18/13. Royal Adhesive & Sealants, LLC - Aerospace & Marine Inflatable Adhesives & Coatings

Division manufactured this material according to internal specifications which include quality control and assurance procedures. The material was manufactured on 11/14/13 against your Purchase Order # 26618.

Shelf Life: 1 year from date of manufacture

Expiration Date: 11/14/14

Sincerely,

Dan Constantino

Daniel Constantino

Royal Adhesives & Sealants, LLC - Aerospace & Marine Inflatable Adhesives & Coatings Division
48 Burgess Place Wayne, New Jersey 07470 Phone: 973-694-0845 Fax: 973-694-5678

TSS 7122/59

TSS 7122-501/10 (80)

INVOICE

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8
Tel: 613-632-1282
Fax: 613-632-2030
GST R132478223
MID : XOTULSAF1123HAW
email: info@tulmar.com

Invoice No Page
51450 1

Invoice date
3/26/2014

Bill To:

Ship To:

Dart Aerospace

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Dart Aerospace

1270 Aberdeen Street
Tel: 613-632-9577
Att: Chantal Lavoie
Hawkesbury, ON K6A 1K7
Canada

Order number 31538 Sales order date 2/4/2014 Account number CDART100 Loc H Account manager 100 Helena Vandeweerd

PO number PO22870 Ship via Pick-Up Shipping Terms FOB HAWKESBURY

Item No. Description	Quantity ordered	Qty Shipped/Returned Quantity on back order	Item price	UOM	Extended Total price
-------------------------	------------------	--	------------	-----	-------------------------

QA-A027 waived
Note = Foam & Fabric as per Dwg

8421-102 D-Pad Assembly, Long Drawing No: B67-43001-85+MU DWG Rev: C+2 A004 A005 A007 A016 A026 A040 A041	20.00	20.00	50.0000	EA	1,000.00
---	-------	-------	---------	----	----------

Lot no.: BATCH0000000009 20.00

8421-101 D-Pad Assembly, Short Drawing No: B67-43001-83+MU DWG Rev: C+1 A004 A005 A007 A016 A026 A040 A041	60.00	60.00	50.0000	EA	3,000.00
--	-------	-------	---------	----	----------

Lot no.: BATCH0000000011 60.00

Comments:

Sales amount: 4,000.00
Miscellaneous amount: 0.00
Freight: 0.00
HST 520.00

Payment terms: Net 30 Days

Total amount due: **4,520.00**
CAD



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO22997**

Purchase Order Date 2/13/2014

PO Print Date 3/4/2014

Page Number 1 of 2

Order From :

VC-TUL001

Ship To : DART AEROSPACE LTD

TULMAR SAFETY SYSTEMS
1123 CAMERON ST
HAWKESBURY, ON K6A 2B8
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone

613 632 1282

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments			Promise Date				
Delivery Comments							

1	111763	PB67-43001-33 UPPER PAD ASSEMBLY	3/7/2014		18.00 ✓	\$75.00	\$1,350.00
			Yes				
			3/28/2014				

FOAM AND FABRIC AS PER DWG

REV.C+1

NOTE: ACCEPTABLE DEVIATION PART ARE NOT AIRWORTHY

FOAM, SBR/EPDM/CR BLEND BLACK, ASTM D1056 2A2, 1/2" THK BRITTLNESS TEMP. OF-40F, IAW ASTM D 746, FMVSS 302

ADHESIVE: LA4009NOVOC

Line Total:

\$1,350.00

2	111762	PB67-43001-35 LOWER PAD ASSEMBLY	3/7/2014		18.00 ✓	\$100.00	\$1,800.00
			Yes				
			3/28/2014				

FOAM AND FABRIC AS PER DWG

REV.C+1

NOTE: ACCEPTABLE DEVIATION PART ARE NOT AIRWORTHY

FOAM, SBR/EPDM/CR BLEND BLACK, ASTM D1056 2A2, 1/2" THK BRITTLNESS TEMP. OF-40F, IAW ASTM D 746, FMVSS 302

ADHESIVE: LA4009NOVOC

Spcl-3-27

PO Instructions: Procurement Quality Clauses

A004 faa-pma/tso

A005 right of entry

A007 first article inspection (fai)

A016 personnel qualification

A026 certification of material conformance

A027 flammability test

A040 notification of quality escape

A041 quality ma

Approved
14/3/14